

Work Order ID 97809

Wednesday, February 27, 2013 9:07:06 AM

97809

AOG

Page 1

Item ID: D3238-5

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Plate

Start Date: 2/27/2013 Start Qty: 10.00

10

Cust Item ID:

Required Date: 2/27/2013 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: *MF*

Date: *3-2-27*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3238

Rev C

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Run "Blank File" in D3238 Note: 1 blank makes 18 prts

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Mill Serration as per Dwg D3238 Using DT8934

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

N
A MF
13-2-27

Work Order ID 97809

97809

Page 2

Wednesday, February 27, 2013 9:07:06 AM

Item ID: D3238-5

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Plate

Stop

NS2

Start Date: 2/27/2013 Start Qty: 10.00

10

Cust Item ID:

Required Date: 2/27/2013 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00

130

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3238 Dwg Rev: C Prog Rev: C 2-
Deburr if necessary

make sure serrations are correct direction!

12

0

Jm13-2-27

140

0.00

140

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

12

0

Jm13-2-27

150

0.00

150

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

to be done by Eric Downing

DAS
16
2-27

13/2/27

(X12)

Work Order ID 97809

97809

Page 3

Wednesday, February 27, 2013 9:07:06 AM

Item ID: D3238-5

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Plate

Stop *NS2*

Start Date: 2/27/2013 Start Qty: 10.00

10

Cust Item ID:

Required Date: 2/27/2013 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00

160

HandFinish

Memo

0.00

Hand Finishing

12 7/16 13.2.27

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control



13/2/27

(712)

180

Identify as per dwg & Stock Location

0.00

180

Packaging

Memo

0.00

Packaging

ST034

12x

SD
13-2-27

Work Order ID 97809***97809***

Page 4

Wednesday, February 27, 2013 9:07:06 AM

Item ID: D3238-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Plate

Start Date: 2/27/2013 Start Qty: 10.00

10

Cust Item ID:

Required Date: 2/27/2013 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

MLJ 13-02-28

MF
13-2-28

Picklist Print

Wednesday, February 27, 2013 9:07:05 A

Page 1

Work Order ID: 97809

Parent Item: D3238-5

Parent Item Name: Plate

Start Date: 2/27/2013

Required Date: 2/27/2013

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 06-10-20 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.080

Purchased

No

100

sf

406.8900

0.012

0.1263158
0.2

Jm 3-2-27

2024-T3 .080 sheet

Location

Loc Qty

Loc Code

MAT022

406.89

105411

12

109424

8

113796

10

114025

3.4

117392

38.2

118180

54

119117

41.15

120989

79.34

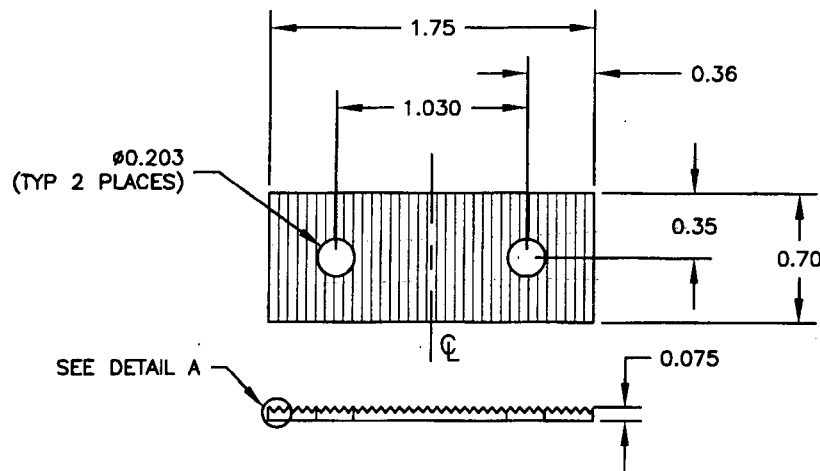
123217

160.8

119117



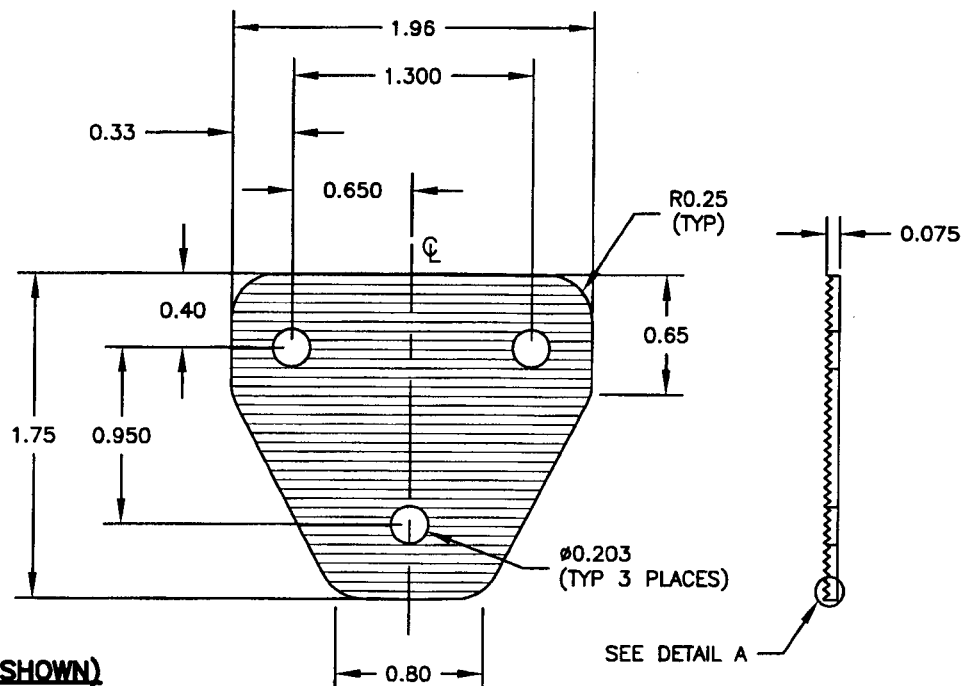
DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 2 OF 3
DATE 07.02.19	TITLE PLATE		SCALE 1:1



RELEASED
07.02.20 #

D3238-5 PLATE (SHOWN)
D3238-15 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

#97809



D3238-21 PLATE (SHOWN)
D3238-31 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.